	er ID 114897 17, 2014 2:31:16 PM		*114	897*						Page 1
Revision ID:	D3536-23		Accept	*N90	<b>0040</b>	1100	)*	Setup St		*NS1*
	Gasket Center  3/17/14			Cust Iter Custome			·	3	op 3	NS2*
Approvals:	Process Plan: _M_5	Date: 14-02-18 Date:	Tooling: SPC (Y/N):		Date:				art y	*NR1* *NR2*
Sequence ID/ Work Center II		:	Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	t Reject Qty		ect Insp. nber Stamp
Draw Nbr D3536	Revision Nbr	÷								
*100 *100 Waterjet FLOW CNC Waterje	FLOW WATER JET  Memo	er Dwg D3536 Dwg Rev:_ necessary	0.00  0.00  Prog Rev:	<b>9</b> _2-			26			Jm14-04-
110 <b>*1 1                                  </b>	QC2- Inspect parts off  Memo	machine FAI/FAIB	0.00				26	<u> </u>		Jm4-04
120 *1 <i>2</i> 0*	QC8- Inspect parts - se	econd check	DAS 0.00 <b>27</b> 9 <b>-8</b> 9 0.00 \\\\\\	1			<u>Xo</u>			12
	Menio		1 11.110	· ·						

Quality Control

DQA:			Date:										TRAC
QA Closed:			Date:		••	WORK ORDER NON-	-CC	ONFO	RMANCE / UPDATE	W	ork Order up	odate only	AEROSPACE
Work Orde	\r.					DISPOSITION			AGAINST		PARTMENT,	· · · · · · · · · · · · · · · · · · ·	
Work Orae	er:					<b>5</b>	1		a		1		· 
Part N	10		·			Rework Scrap			Skid-tube Crosstube  Machining Small Fab	-	Pro	Water Jet d. Eng. Coor.	Engineering Quality
NCR N	10					Use-as-is Suspected Unapproved		Thern	noforming Finishing Large Fab Composite	-	Rec/Sto	re/Packaging Supplier	Other
Root					Descr	iption of work order update		nitial	Action		Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
Design													
Doc/Data													
Equip/Tooling													
Handling/Pre													
Material									·			-	
Operator		l											
Offset/Setup									,				
Process													
Supplier													
Training		j											
Transport													
Unapproved													
							FAL	ULT CAT	ΓEGORY		•		
Landi	ng Gea	r				General					-	_	_
	Bei	nding				Bend		Folio/P	Program		Outside Dim	ensions	Pressure/Forced
	Cei	ntre No	t Concer	ntric		BOM/Route		Grain			Over/Under	tolerance	Set-up
	Cra	icks				Broken/Damage/Defect		Hardwa	are		Part Incorred	ાં	Temperature/Cure
	Cri	mp/Kin	k/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Unqualified		Part Lost/Mi	ssing	Weld
	Cut	ffs				Contamination		instruct	tions Incomplete/Unclear		Part Moved		Wrong Stock Pulled
	_	ıshing			L_	Countersink		Misalig	gned/off center		Positioned V		
		at Treat				Cut Too Short		Mislabe	eled		Power Loss/	Surge	Other
	Ins	pection	Strip in	Tube		Drawing		Misread	d				
	Ma	rks/Cha	atter			Drill Holes		Off-set					
	Tuı	rning Se	equence		_	Finish		Out of 0	Calibration				
	wa	ve/Twi	st in Tub	e		Fit/Function		Out of 9	Seguence		<u> </u>		

W	ork	Orde	er ID	114897

Monday, March				*114	189/*							Page 2
Revision ID:	D3536-23 Gasket Center		Ā	Accept	*N900	<b>040</b>	100	)* s		Start Stop		S1* S2*
Start Date: Required Date: Reference:	3/17/14 3/17/14	<b>Start Qty:</b> 18.00 <b>Req'd Qty:</b> 18.00	*18* *18*		Cust Item II Customer:	D:						.,
Approvals:	Process Plan	n:	Date:	Tooling: SPC (Y/N):		ite:		F		Start Stop	*NI	R1* R2*
Sequence ID/ Work Center II  130  *120* Packaging Packaging	)	Operation Description Identify as per dwg & Stoo	k Location FJ 66	Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Reje Qty		Reject Number	Insp. Stamp
140 <b>*1 4 0 *</b> QC Quality Control		QC21- Final Inspection - V	Work Order Release	0.00				_MCO	<u> </u>	Y0-	-01	

U 4.04,88

DQA:			Date:						_						TRAGC
QA Closed:			Date:		÷	WORK ORDER NON-	-CC	ONFO	RMANCE / UI		Wo	ork Order up	odate only	7	AEROSPACE
						DISDOSITION				· • · · · · · · · · · · · · · · · · ·					
Work Orde	er: _					DISPOSITION				AGAINST I	DEF	PARTMENT	PROCESS		·
		•				Rework			Skid-tube	Crosstube			Water Jet		Engineering
Part N	۱o	<del>-</del> -				Scrap			Machining	Small Fab			d. Eng. Coor.		Quality
					1	Use-as-is		Therr	noforming	Finishing		Rec/Stor	e/Packaging	_	Other
NCR N	۱o					Suspected Unapproved			Large Fab	Composite			Supplier	┙	
Root					Descr	iption of work order update		nitial	Act	ion		Sign &	· · · · · · · · · · · · · · · · · · ·		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descr	iption		Date	Verification		QC Inspector
Design															
Doc/Data						·								-	
Equip/Tooling	Ш					'									
Handling/Pre											1				
Material															
Operator															
Offset/Setup	Щ										İ				
Process									: 						
Supplier	Ш					•						•			
Training															
Transport	Ш														
Unapproved				<u> </u>	<u> </u>								<u> </u>	$\bot$	
		_				· ,· ,· · · · · · · · · · · · · · · · ·	FAI	ULT CA	regory						
Landi	_				_	General		1	_	г	_				
	-	Bending				Bend	<u> </u>	1	Program	-	$\dashv$	Outside Dim	<u> </u>	— 1	ressure/Forced
		Centre No	ot Concer	ntric	<u> </u>	BOM/Route		Grain		1	-	Over/Under	<del>}</del>		et-up
	Н	Cracks			<u> </u>	Broken/Damage/Defect	<u> </u>	Hardwa				Part Incorred	<u> </u>	_	emperature/Cure
	-	Crimp/Kin	ık/Ripple	/Wave	<u> </u>	Burrs	<u> </u>	4	ion Incomplete/Ur	· .	-	Part Lost/Mi	ssing	_	/eld
	${f H}$	Cuffs				Contamination		4	tions Incomplete/l	Jnclear	-	Part Moved	L	<b></b> ۱۳	/rong Stock Pulled
	-	Crushing			<u> </u>	Countersink	<b> </b>	4	gned/off center		-	Positioned V		$\neg_{\sim}$	Ala a u
	$\vdash$	Heat Trea		<b>T.</b> l	$\vdash$	Cut Too Short	$\vdash$	Mislab		Į		Power Loss/	Surge	To	ther
	$\boldsymbol{\vdash}$	Inspection		rube		Drawing	<u> </u>	Misrea				<del></del>			<del>-</del>
	$\vdash$	Marks/Ch				Drill Holes	-	Off-set			,				
_	$\boldsymbol{-}$	Turning S			-	Finish	_	4	Calibration				<del></del>		
· · ·		Wave/Tw	ist in Tub	oe		Fit/Function		Out of	Sequence						

**Picklist Print** 

Monday, March 17, 2014 2:31:16 PM

Work Order ID: 114897

\*114897\*

Parent Item:

D3536-23

\*D3536-23\*

Parent Item Name: Gasket Center

**Start Date:** 3/17/14

Required Date: 3/17/14

Page 1

**Start Qty: 18.00** 

Required Qty: 18.00

**Comments:** 

IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Primary Item Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MNEO60S.063		Purchased	No		100	sf	1,129.100	1.3365	2 <del>6.73</del>			-
*MNEO60	S 063*							**	28			Tralle

**NEOPRENE SHEET 0.063** 

<b>Location</b>	Loc Qty	Loc Code	
MAT052	1129.1		
M126546	27.1		
M128266	302		138366
M128339	800		

DQA:			_ Date:								·		•		TO AC
						WORK ORDER NON	-CC	ONFO	RMANCE / U			•			AEROSPACE
QA Closed:			Date:					·			W	ork Order u	odate only		
Work Orde	er:					DISPOSITION				AGAINST	DE	PARTMENT	/PROCESS		
	•					Rework	1		Skid-tube	Crosstube		]	Water Jet		Engineering
Part N	No.					Scrap	1		Machining	Small Fab		Pro	d. Eng. Coor.		Quality
,	•					Use-as-is	1		noforming	Finishing		1	re/Packaging		Other
NCR I	۷o.					Suspected Unapproved	1		Large Fab	Composite	_	1	Supplier		ļ. <b>1</b>
												·			
Root					Desc	ription of work order update	1	Initial	Ac	tion		Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	nief Eng	Desc	ription		Date	Verification	n	QC Inspector
Design						•									
Doc/Data							1								
Equip/Tooling	$\square$	•											,		
Handling/Pre	$\blacksquare$														
Material	Щ					,			! !						
Operator						·									
Offset/Setup	$\vdash$														
Process	Н														
Supplier	Н			i											
Training Transport		`													
Unapproved				·											
опарриотеа			1.	<u>!</u>			FAI	ULT CA	TEGORY			<u> </u>	<u> </u>		
Landi	ng G	iear				General						•			
		Bending	•		Г	Bend		Folio/F	Program	Ī		Outside Dim	ensions		Pressure/Forced
		Centre No	ot Concer	ntric		BOM/Route		Grain	-			Over/Under	tolerance		Set-up
		Cracks				Broken/Damage/Defect		Hardwa	are	ļ		Part Incorre	ci		Temperature/Cure
		Crimp/Kii	nk/Ripple	/Wave		Burrs		Inspect	ion Incomplete/U	nqualified		Part Lost/M	issing		Weld
		Cuffs				Contamination		Instruc	tions Incomplete/	Unclear		Part Moved			Wrong Stock Pulled
		Crushing				Countersink		Misali	gned/off center			Positioned \	Vrong		•
	$\vdash$	Heat Trea				Cut Too Short		Mislabe	eled			Power Loss/	Surge		Other
		Inspectio	-	Tube	_	Drawing		Misrea							· · · · · · · · · · · · · · · · · · ·
	<u> </u>	Marks/Ch			<u> </u>	Drill Holes		Off-set							
		ł	equence		$\perp$	Finish		-1	Calibration						
L_	ł	Wave/Tw	vist in Tub	e	. 1	Fit/Function	1	Out of	Sequence						

DART AEROSPACE LTD	Work Order: 114897	-
Description: Gasket	Part Number: D3536-	23
Inspection Dwg: D3536 Rev: A	Page 1 c	of 1

## FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
52.85	+/-0.030	52.85	_		1	Jkmo 7
48.20	+/-0.030	48.20"	_		T	
44.70	+/-0.030	44.70	_		7	
39.31	+/-0.030	39.31"	_		T	
33.92	+/-0.030	33.95			T	
28.53	+/-0.030	28.53"	_		T	
23.14	+/-0.030	23.14	_		T	
17.75	+/-0.030	17.75	_		T	
14.25	+/-0.030	14.25			T	
9.50	+/-0.030	9.50	-		V	Jamos
4.75	+/-0.030	4.75	_		ν ,	Jkmos
8.00	+/-0.030	8.00			٧	
16.00	+/-0.030	16.00			Т	
24.00	+/-0.030	24.00	_		_T	
32.00	+/-0.030	35.00			Т	
39.00	+/-0.030	39.00	_		T	
48.00	+/-0.030	48.00			T	
0.30	+/-0.030	0.30°	_		V	
0.30	+/-0.030	0.30°			V	
1.89	+/-0.030	1.89	-		V	
Ø0.19	+0.005/-0.001	0.19"			V	

Measured by: Jm Audited by: 27 Prototype Approval: N/A

Date: M-04-6 Date: N/A

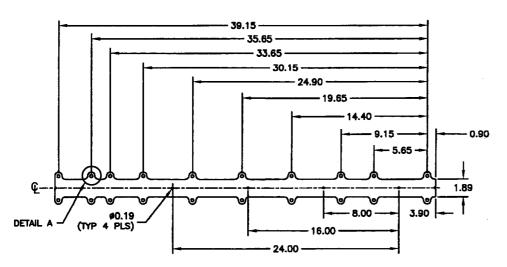
Rev	Date	Change	Revised by	Approx/ed
Α	07.03.14	New Issue	KJ/JLM	

뒾동 Copyright @ 2006 by DART AEROSPACE USA, INC.

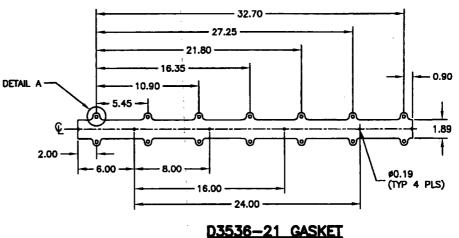
DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC. B. 62.12 26.65 -- 17.65 --13.40 0.90 - 5.65 1.89 114897 MLJ 14-03-18 3.90 DETAIL A ø0.19 (TYP 3 PLS) <u>0</u>6. PATE CHECKED D3536-11 GASKET 5 B Œ 06.10.25 29.40 27.40 -23.90 18.98 D3536 GASKET DRAWING NO NEW ISSUE 14.07 DART 0.90 5.65 AEROSPACE 1.89 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063) DETAIL A 3.90 2) FINISH: NONE 14.00 #0.19 (TYP 4 PLS) ) PART IS SYMMETRICAL ABOUT ©
) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED 20.00 D3536-13 GASKET 5) ALL DIMENSIONS ARE IN INCHES PURPOSE DENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER 7) SEE PAGE 6 FOR DETAILS AND SECTION SHEET 욹 ₹ C. COPIED SCALE OF 6 1:10

07.02.12

			00.10.20	
	GASKET		06 10 25	
SCALE			DATE	
SHEET 2 OF 6	D3536	4	7	
REV. A	DRAWING NO.	APPROVED #	CHECKED	
PORT HADLOCK, WA		CB	CB	
DART AEROSPACE USA. INC.	DART	DRAWN BY	) )	



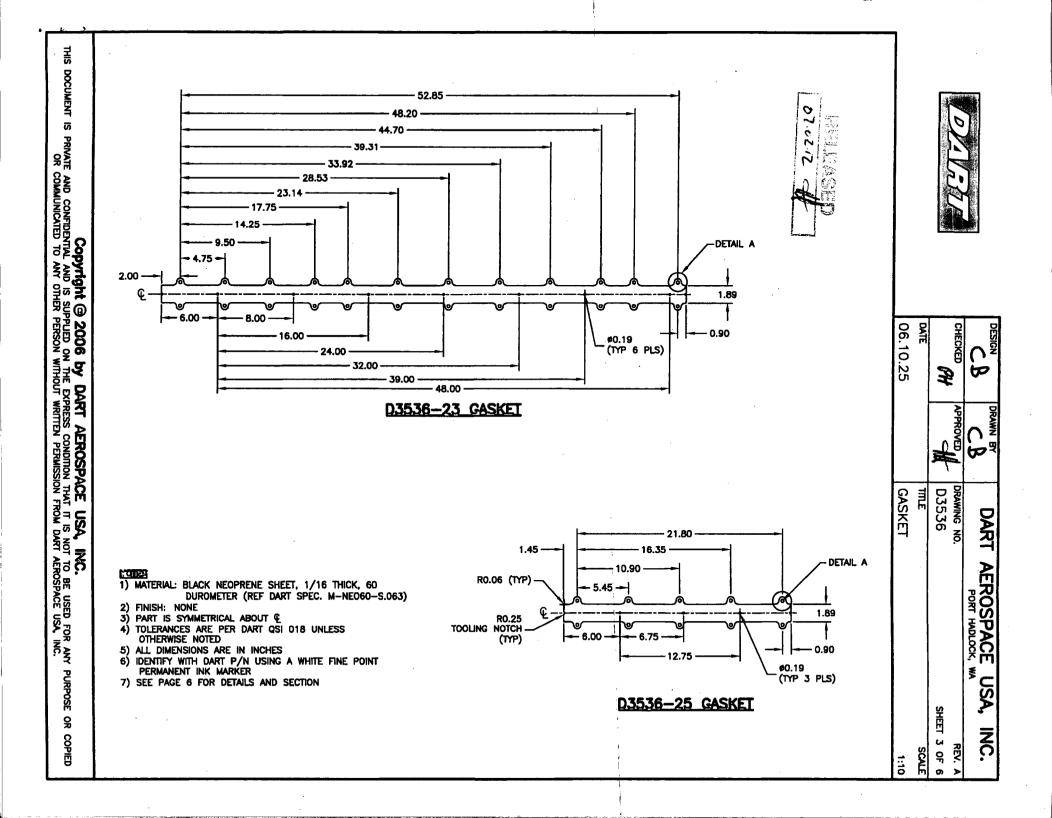
D3536-15 GASKET



- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)

- 2) FINISH: NONE
  3) PART IS SYMMETRICAL ABOUT &
  4) TOLERANCES ARE PER DART QSI 018 UNLESS
  OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
  6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

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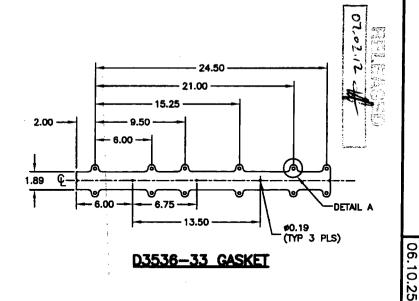


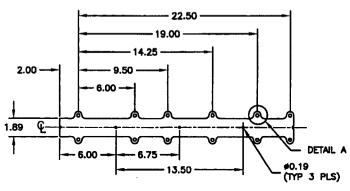
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GASKET





D3536-31 GASKET

# 23.25 19.75 17.75 2.00 -4.75 1.89 #0.19 (TYP 2 PLS) DETAIL A

D3536-35 GASKET

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE

- PART IS SYMMETRICAL ABOUT ©
  TOLERANCES ARE PER DART QSI 018 UNLESS
  OTHERWISE NOTED
  ALL DIMENSIONS ARE IN INCHES
  IDENTIFY WITH DART P/N USING A WHITE FINE POINT
  PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

PURPOSE

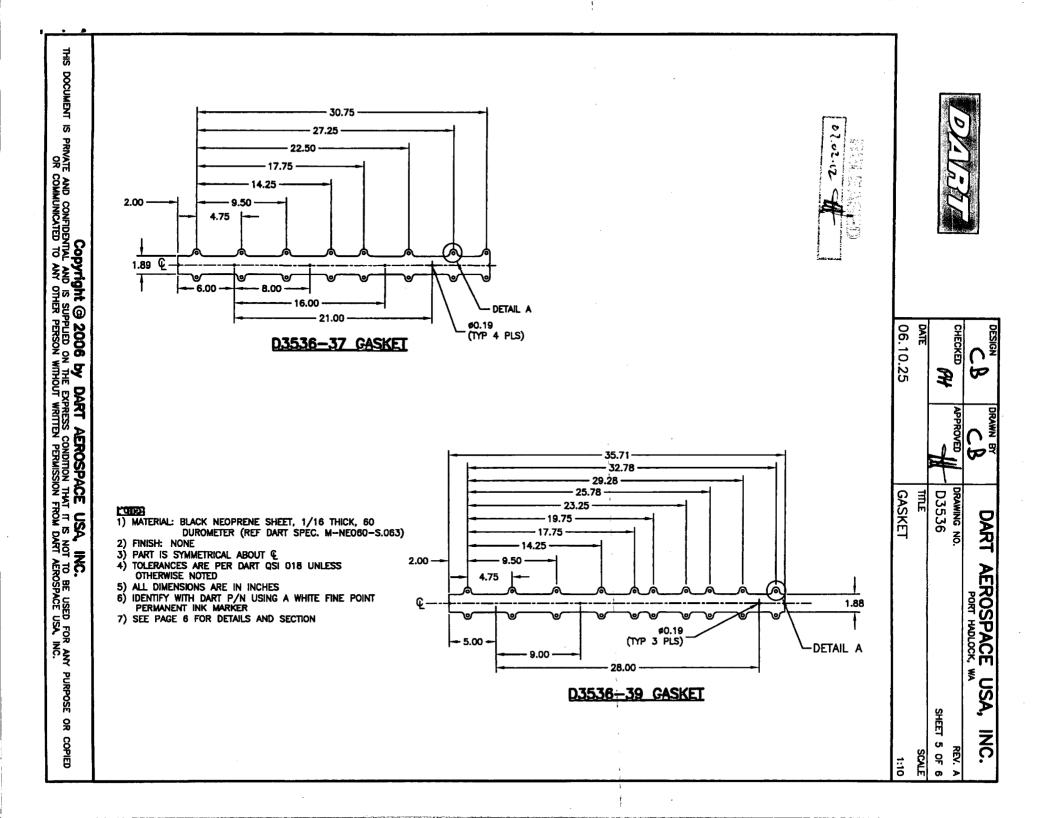
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- 27.98 25.08 18.50 15.00 2.00 -3.43 1.88 4.00 #0.19 (TYP 2 PLS) DETAIL A

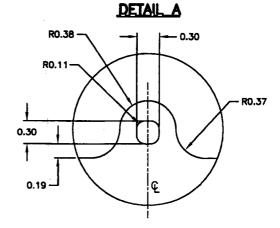




### D3536-41 GASKET

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)

- 2) FINISH: NONE
  3) PART IS SYMMETRICAL ABOUT &
  4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER



CB	CB	DART AEROSPACE USA, INC.
CHECKED	APPROVED //	DRAWING NO. REV. A
110	#	D3536 SHEET 6 OF 6
DATE		TITLE SCALE
06.10.25		GASKET 1:10